

Work Order ID 79815

79815

Page 1

February-03-12 12:53:10 PM

Item ID: D105-674-011G

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube, Grey

Start Date: 03/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/02/03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2966	Rev A2

100 DOCUMENT CONTROL 0.00

100

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D105-674-011G CHG002

130 Skidtubes 0.00

130

Skidtubes

Skidtubes

Memo

0.00

** Pull D2966-1 bent **

- 1-Cut Aft end at 107.06" using DT8185D
- 2-Debur ends
- 3-Drill Aft Cap holes using DT8678
- 4-Locate DT8679 with 1/8 clecos in Aft Cap holes. Ensure DT8679 is centered on Fwd end of tube and drill #40 Fwd bushing.
- 5-Clamp DT8679 to the tube. Drill all #30 wearplate and crossbolt holes.
- 6-Open Aft Cap holes using #6 drill
- 7-Open wearplate holes and two side holes to 31.9/64" (0.297") as per Dwg D2966-1.
- 8-Debur holes.
- 9-Open remaining (16) crossbolt holes to Ø0.500

12-02-24

SAD

12-02-15

B7981

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Item ID: D105-674-011G

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube, Grey

Start Date: 03/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Chemical Conversion Coat per QSI005 4.1	0.00							
170									
HandFinish	Memo	0.00							
Hand Finishing									
180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									
190		0.00							
190									
Skidtubes									
Skidtubes	Memo	0.00							
Skidtubes	1-Open crossbolt holes to finish size as per Dwg D2966 2-Open 14 holes to Ø0.750" & 2 holes to Ø0.875", countersink crossbolt holes & remove alodine to prepare for welding as per Dwg D2966 3-Deburr holes inside & outside, blow out chips								

1 0 CF 12-3-15

QC 12-3-15

1 0 CF 12-3-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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February-03-12 12:53:11 PM

Item ID: D105-674-011G

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube, Grey

Start Date: 03/02/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: * Process Plan: _____ Date: _____ Tooling: _____ Date: _____

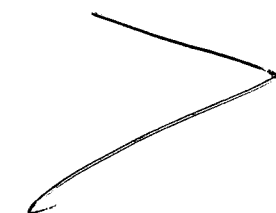
Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Skidtubes	0.00							
200									
Skidtubes	Memo	0.00							
Skidtubes	1-Bond Web in place per QSI 015. (Ensure holes line up) Pick: A/R Sikaflex-291 batch: <u>M120813</u> Sikaflex expiry date: <u>12-8-13</u> start time: <u>5pm</u> end time: <u>12-03-16 9:30am</u>								
	2-Weld Crossbolt Spacers as per Dwg D2966 and QSI 004. For crossbolt spacer, weld one side, pass 5/8" drill; weld other side, pass 5/8" drill. Pick: A/R Aluminum Rod batch: <u>M120164</u>								
	3-Pass Ø0.630" drill to remove spillover for D2973 crossbolt. Pass Ø0.750" drill to remove spillover for D2971 crossbolt.								
	4-Grind welds flush as per Dwg D2966								
210	QC10- Inspect visual per QSI004- ground welds	0.00							
210									
QC	Memo	0.00							
Quality Control									

SAD 12-03-15



86 12/03/16

CF 12-3-16

12-03-19 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Skidtube, Grey

Start Date: 03/02/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC5- Inspect part completeness to step on W/O	0.00							
220									
QC	Memo	0.00							
Quality Control									
225	Chemical Conversion Coat per QSI005 4.1	0.00							
225									
HandFinish	Memo	0.00							
Hand Finishing									
230	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
230									
Powdercoat	Memo	0.00							
Powder Coating									




12-03-19

12-3-19

12-3-23

U220 Hand Finishing inst 21/ AL57-1032-130 MS227034-1-08, AN960JD10L in 2 places before powder coating

11/8/18
START TIME: 1:15
OVEN TEMPERATURE: 300
FINISH TIME: 1:45

W/O: 7978 15		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/03/23	226	permanent change		12.04.03		 12/03/23	

Part No: P 105-674-011⁶ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube, Grey

Start Date: 03/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC3- Inspect Part Finish

0.00

240

QC

Memo

0.00

Quality Control

1X M-12/03/26

250

HandFinishing

0.00

250

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for foreign objects as per QSI 024

2-Install Inserts, Wearplate and Cap per Dwg D2966. Insert a drop of sikaflex at insert holes before installing wearplates. Seal Aft Cap using Sikaflex. Install bushing and nut. By looking Fwd, install nut to right hand side.

Pick:

QtyPart NumberDescriptionBatch
A/RSikaflex-291 *M119443*

Sikaflex expiry date: *12/10*

3-Wing Walk as per Dwg D2966 and QSI 005 4.4

Batch: *120902*

1X M-12/03/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Item ID: D105-674-011G

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube, Grey

Start Date: 03/02/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00							
Quality Control									
270	QC5- Inspect part completeness to step on W/O	0.00							
270									
QC	Memo	0.00							
Quality Control	*****ENSURE INSERT ARE AT LOCATION (6) AS PER DWG D2966*****								
280	Pick Kit	0.00							
280									
Packaging	Memo	0.00							
Packaging									

[Handwritten signature]

1x SP 12-03-29.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79815***79815***

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Item ID: D105-674-011G

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube, Grey

Start Date: 03/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290	QC4- 100% Inspect kits for completeness	0.00							
290									
QC	Memo	0.00							
Quality Control									
300	Packaging	0.00							
300									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D105-674-011G								
	Location: _____								
	<i>Rev A</i>								
310	QC21- Final Inspection - Work Order Release	0.00							
310									
QC	Memo	0.00							
Quality Control									

*1X SP 12-03-29**MCS 12/04/02**12-04-2*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 1

Work Order ID: 79815

79815

Parent Item: D105-674-011G

D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A04.07.07New IssueKJ/JLM
seq110 DD verf:EC

IPP Rev:B 10.06.09 remove

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2966-1-BENT		Manufactured	No			130	Each	0.0000	1	1			
D2966-1-BENT						B77227			**			12/03/24	
Skidtube Assembly 105													
D2964		Manufactured	No			140	Each	29.0000	1	1			
D2964									**			BE 12/03/15	
Cap													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
						LG002		29					
					74719			29					
D2976		Manufactured	No			200	Each	0.0000	1	1			
D2976						80094			**			12-3-15	
BO 105 Skidtube I Beam													
D2971		Manufactured	No			200	Each	34.0000	1	1			
D2971									**			BE 12-03-16	
Cross Bolt Spacer													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
						LG001		34					
					74720			34					
D2973		Manufactured	No			200	Each	58.0000	7	7			
D2973									**			BE 12-03-16	
Cross Bolt Spacer													
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
						LG002		58					
					14636			58					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 79815

79815

Parent Item: D105-674-011G

D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2965 Manufactured No

250 Each 22.0000 1 1

D2965

Cap, 105 Skidtube

81926 **
Location Loc Qty Loc Code
 FP002 22
 71371 22

m.d 12/03/26
 *

D2970-1 Manufactured No

250 Each 7.0000 1 1

D2970-1

Wearplate

Location Loc Qty Loc Code
 FP001 7
 48213 ✓ 7

m.d 12/03/26

D2970-3 Manufactured No

250 Each 5.0000 1 1

D2970-3

Wearplate

Location Loc Qty Loc Code
 FP001 5
 48214 ✓ 5

m.d 12/03/26

D3176-1 Manufactured No

250 Each 10.0000 1 1

D3176-1

Bushing

Location Loc Qty Loc Code
 ST032 10
 37586 ✓ 10

m.d 12/03/26

D3176-3 Manufactured No

250 Each 13.0000 1 1

D3176-3

Nut

Location Loc Qty Loc Code
 ST032 13
 44896 ✓ 13

m.d 12/03/26

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D105-674-011G

D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

250

Each

2,472.000

36

36

AI S7-1032-130

Insert

**

M-L 12/03/26

Location

Loc Qty

Loc Code

ST280

328

117717

27

118966

22

119775

279

ST281

71

119794

71

ST282

2073

119530

73

120181

2000

MS27039-1-08

Purchased

No

250

Each

1,559.000

26

26

MS27039-1-08

Screw

**

M-L 12/03/26

Location

Loc Qty

Loc Code

ST291

1559

117423

77

118910

2

119075

292

119109

188

120308

1000

AN960JD10L

NAS1149D0332J

Purchased

No

250

Each

0.0000

28

28

*AN960JD10L *

Washer

**

120644

28 x M-L 12/03/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D105-674-011G

D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-09

Purchased

No

250

Each

455.0000

2

2

MS27039-1-09

Screw

**

M-12/03/26

Location

Loc Qty

Loc Code

FP002

161

18057 ✓

161

ST291

294

111650

294

D2972

Manufactured

No

290

Each

51.0000

6

6

D2972

Bushing

**

SP

Location

Loc Qty

Loc Code

ST022

51

33544

20

44160

31

D2974

Manufactured

No

290

Each

41.0000

1

1

D2974

Packer

**

Cor

Location

Loc Qty

Loc Code

ST022

41

71997

41

D2975

Manufactured

No

290

Each

6.0000

2

2

D2975

Wearshoe

**

IX

Location

Loc Qty

Loc Code

ST497A

6

74721

6

2X

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D105-674-011G

D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-51A

Purchased

No

290

Each

260.0000

3

3

AN4-51A

Bolt

**

Location

Loc Qty

Loc Code

ST361

260

119127

30

119798

30

120187

200

AN960JD10L

NAS1149D0332J

Purchased

No

290

Each

0.0000

8

8

*AN960.ID10I *

Washer

**

MS21042L4

Purchased

No

290

Each

6,070.000

3

3

MS21042I 4

Nut

**

Location

Loc Qty

Loc Code

ST300

6070

117441

51

117601

157

118451

133

119017

729

119075

5000

MS27039-1-08

Purchased

No

290

Each

1,559.000

8

8

MS27039-1-08

Screw

**

Location

Loc Qty

Loc Code

ST291

1559

117423

77

118910

2

119075

292

119109

188

120308

1000

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED
00.05.11 #

Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT

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NO. 34004
7/8/15 12/02/03
MCS

A2

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.4) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)

A1

01.01.29
IP 01.01.30

A2	02.10.30	ADD D3176-1/-3	# CP
A1	01.01.29	CHANGE COLOR TO BLACK SANDTEX	# CP

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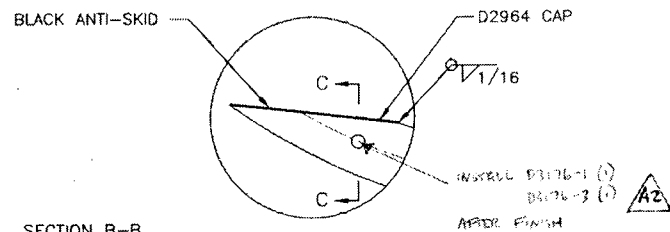
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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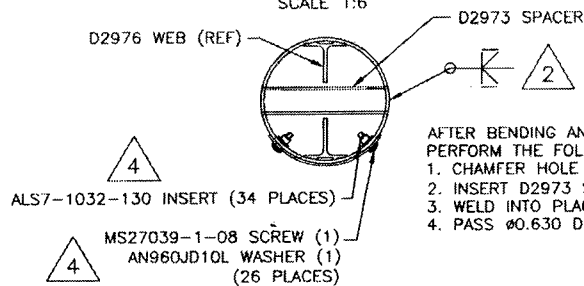
NOTE: Date & initial all entries

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DETAIL A
SCALE 1:3

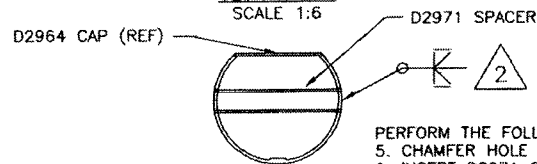


SECTION B-B
SCALE 1:6



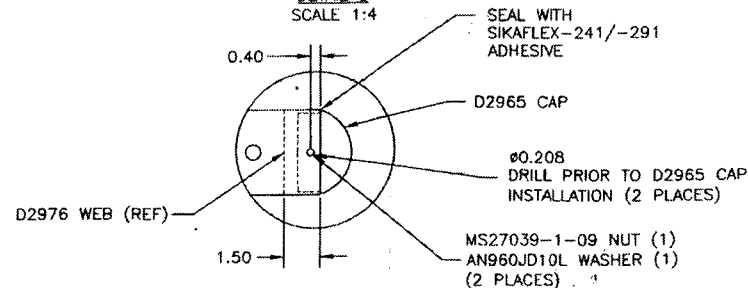
- AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.750$ HOLES ONLY:
1. CHAMFER HOLE $0.030 \times 45^\circ$
 2. INSERT D2973 SPACER (7 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS $\phi 0.630$ DRILL TO REMOVE SPILL OVER

SECTION C-C
SCALE 1:6

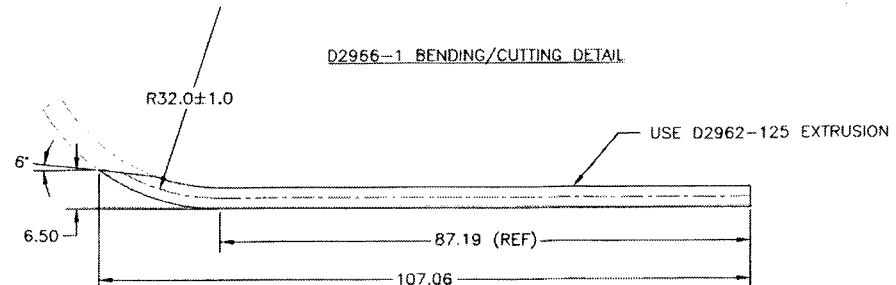


- PERFORM THE FOLLOWING FOR $\phi 0.625$ HOLES ONLY:
5. CHAMFER HOLE $0.030 \times 45^\circ$
 6. INSERT D2971 SPACER
 7. WELD INTO PLACE AND GRIND FLUSH
 8. PASS $\phi 0.484$ DRILL TO REMOVE SPILL OVER

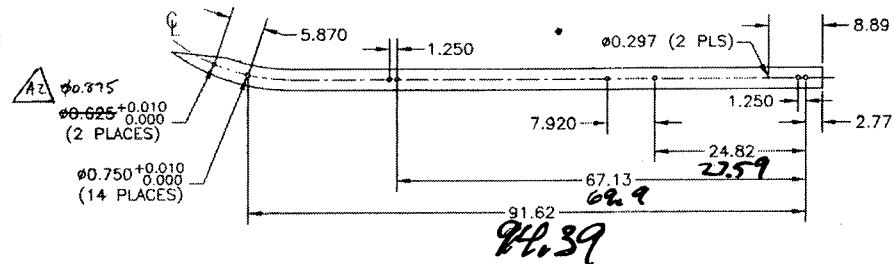
DETAIL D
SCALE 1:4



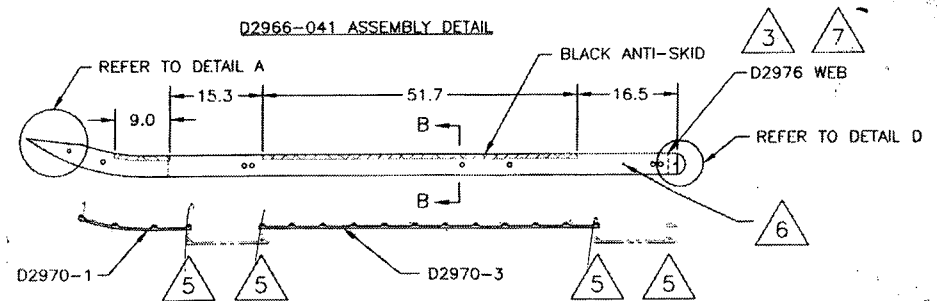
D2966-1 BENDING/CUTTING DETAIL



D2966-1 DRILLING DETAIL



D2966-041 ASSEMBLY DETAIL



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DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY		SCALE 1:20	

RELEASED
05-05-18

W/O:		WORK ORDER CHANGES					
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